

Work Order ID 51802

Thursday, September 03, 2009 11:42:50 AM

Page 1

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *RP*Date: *09-2-02* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

*509/1/2**51802*

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Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Setup Start

Stop

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

□ m11682

10-Grind welds flush as per Dwg D2750

BE 09/09/17

DP 9-9-28

BE 09/09/17

DP 9-9-28

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Item ID: D350-636-011

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Start Date: 9/3/2009 Start Qty: 1.00

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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12- Scribe batch# inside per dwg D2750

DP 9-9-28

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

=> 8/31/09

(10) 4

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> 8/31/09

(12) 4

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

mm 09 09 29 (1)

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Start Date: 9/3/2009 Start Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



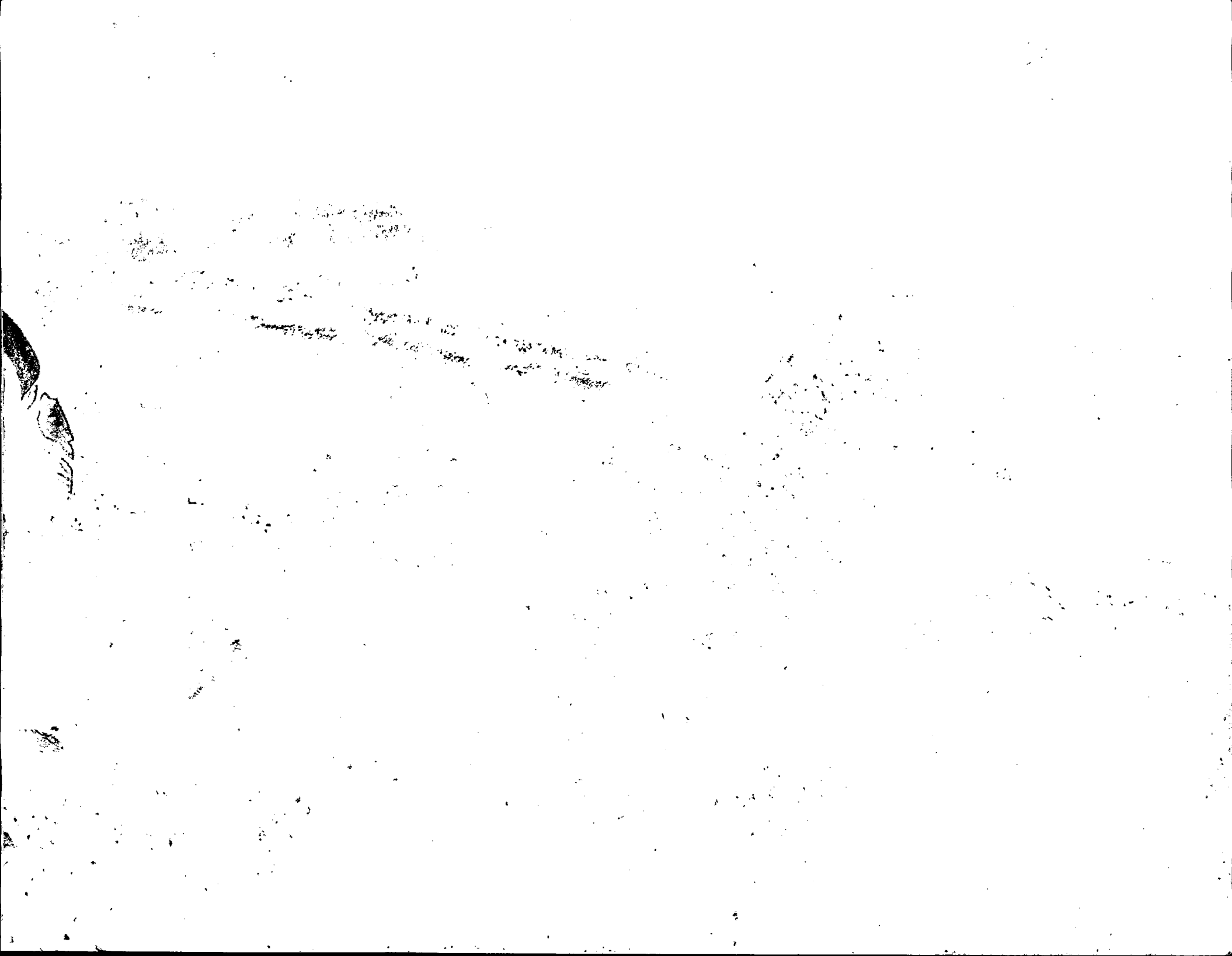
QC

Memo

0.00

Quality Control

Q-M 09 - 10 - 13 @



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Item ID: D350-636-011

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Setup Start

Stop

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
Skidtubes	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>M 112391</u> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> exp. date: <u>2010/02</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M111997</u> <u>BE</u> <u>09-10-13</u>								
	9-Grind welds flush as per Dwg D2750 <u>BE</u> <u>09-10-13</u>								
	10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 <u>BE</u> <u>09-10-13</u>								

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Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Deburr holes

BE 09/10/13

170

QC10- Inspect visual per QSI004- ground welds

0.00

27 809/10/13



QC

Memo

0.00

Quality Control

(X)

Ø

180

QC5- Inspect part completeness to step on W/O

0.00

27 809/10/13



QC

Memo

0.00

Quality Control

(X)

Ø

190

Pressure Wash per QSI005 4.3

0.00

27 809/10/14



HandFinish

Memo

0.00

Hand Finishing

(X)

Ø

00000000000000000000000000000000

Thursday, September 03, 2009 11:42:50 AM

Accept

**Setup Start**

Stop

Fig. 1. *Phragmites* (a) and *Spartina patens* (b) stands in the upper and lower marshes of the tidal freshwater marshes of the York River, Virginia. The upper marsh is characterized by a higher elevation and a higher water table, while the lower marsh is characterized by a lower elevation and a lower water table.

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[illegible]

M112260

Powdercoat

Memo

Powder Coating

START TIME: 10:45 AM
OVEN TEMPERATURE: 320 °F
FINISH TIME: 11:15 AM

0.00

\Rightarrow ११ ०९/१०/१५

VI 2

0.00



MO 9/10/2

QC

Memo

Quality Control

Inspect for foreign object per QSI 024

0.00

21

0.00

[REDACTED]

MO 09/10/21

HandFinish

Memo

Hand Finishing

1- Install inserts as per Dwg D2750

0.00

X

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Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: 11/1A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m112391

EXP DATE: 10/20

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: m101223

5-Coat all exposed fasteners with "LPS Procyon" batch: m104251

0.00

0.00

0.00

0.00

X1

m009110121

250/1017

(16)

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/23

sf @

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

> 8/10/26

⊗

✱

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

Loc 72

R009

9/10/26 @ sf

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Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9-10-28

PL 09-10-24

Picklist Print

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Thursday, September 03, 2009 11:42:58 AM

Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	50.0000	1.0000			
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 50

44892 15

47488 35

D2600-3-BENTRevD1

Manufactured

No

110

Each

0.0000

1.0000



Extrusion Bent

D2743RevB

Manufactured

No

160

Each

294.0000

8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 50

50281 50

Main Warehouse

ST 244

44891 2

45555 177

48275 65

1 BE 09/09/17
8 50675 (1) BE 09/09/17

8 BE 09/10/13

Picklist Print

Thursday, September 03, 2009 11:42:59 AM

Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
350 I Beam												

B. 52305 MB 09-10-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

112

45560

22

47471

35

48276

55

4 BB 09/12/13

Picklist Print

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Work Order ID: 51802

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA		Manufactured	No			160	Each	165.0000	4.0000			
												
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	165
45338	2
47118	4
47657	50
48277	109

4 BE 09/10/13

ALS4-1032-225 Purchased No



Insert

220 Each 8,785.000 38.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8785
107441	16
<u>10768</u>	8769

X38 MD 09/10/21

D3492-041RevC Manufactured No



Plug Assembly

230 Each 3.0000 8.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3
43816	3

X8 MD 09/10/21

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Shop Packet Print

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Picklist Print

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Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA		Manufactured	No			230	Each	22.0000	1.0000			



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 22

47720 11

50216 11

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 167

102180 1

106896 1

110105 65

110847 100

21 mp 09/10/21

21 mp 09/10/21

Picklist Print

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Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

40551

1

47537

4

50231

13

XL mD09/10/21

D3488-041RevB

Manufactured

No

230

Each

29.0000

1.0000



Blade Fitting Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

41853

1

44530

8

47348

20

XL mD09/10/21

Picklist Print

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Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA		Manufactured	No			230	Each	27.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

46531

2

47440

2

47722

11

50240

12

XI m009110/21

AN6C44A

Purchased

No

230

Each

172.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

170

110105

4

110155

14

110665

1

110865

51

111605

50

111649

50

XY m009110/21

Picklist Print

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Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8		Purchased	No			230	Each	92.0000	1.0000			



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

21 MD 09/10/21

D3536-25RevA

Manufactured No

230

Each

21.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	21	
45569	1	
47011	2	
47526	8	
50266	10	

51607

21 MD 09/10/21

Picklist Print

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Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	5908	
ST	105	
38139	6	
45353	16	
47437	83	

X8 MD 09/10/21

D3791-1RevA  Wearplate		Manufactured	No			230	Each	18.0000	1.0000			
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<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	51610	
ST	18	
47536	8	
50269	10	

XL MP 09/10/21

X1 MD 09/10/21

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Required Date: 9/15/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,450.000	38.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
FP	-44	
112116	-44	
Main Warehouse		
ST	2394	
112116	2394	
112612		

138 MD 09/10/21

Picklist Print

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Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			
Bushing												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	272	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	19	
43754	2	
44893	37	
45556	69	
46695	18	
48278	110	

X8 MD 09/10/21

AN3C5A

Purchased

No

230

Each

646.0000

34.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	646	
111424	8	
111707	338	
112314	200	
112489	100	
112720		

X6 MD 09/10/21
X8

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	46.0000	3.0000			

Wearpad

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	46	
48288	3	
50321	43	

X3 MD 09/10/21

AN960C816L

Purchased

No

230

Each

330.0000

1.0000

WASHER

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

X1 MD 09/10/21

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000

Plug Assembly

52309

X8 MD 09/10/21

Thursday, September 03, 2009 11:42:59 AM

Shop Packet Print

Page 11

Picklist Print

Page 12 / 17

Thursday, September 03, 2009 11:42:59 AM

Work Order ID: 51802

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A 		Purchased	No			230	Each	1,048.000	4.0000			
BOLT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1048

110372 72

111982 976

NAS1611-013

Purchased

No

230

Each

320.0000

1.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 320

106513 11

111424 109

111758 200

NAS1611-010

Purchased

No

230

Each

345.0000

1.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 345

110715 50

110915 295

✓ mo 09/10/21

✓ mo 09/10/21

870
Last page

Thursday, September 03, 2009 11:42:59 AM

Shop Packet Print

Page 12

Picklist Print

Thursday, September 03, 2009 11:42:59 AM

Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB		Manufactured	No			230	Each	11.0000	1.0000			

Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	11	
47523	11	

51603

XL MD 09/10/21

D3794-1RevA

Manufactured No



Gasket

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	7	
46530	1	
47212	2	
47721	4	

51608

XL MD 09/10/21

MS21043-6

Purchased No



NUT

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1132	
110584	34	
111424	98	
112314	1000	

111424

XL MD 09/10/21

Picklist Print

Thursday, September 03, 2009 11:42:59 AM

Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S

D3493-1RevA

Manufactured

No

260

Each

115.0000

2.0000



Washer

[Handwritten signature]

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

47710 *sel*

S

MS21083C8

Purchased

No

260

Each

92.0000

2.0000



NUT

[Handwritten signature]

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

112243 *9/10/03 sel*

Picklist Print

Thursday, September 03, 2009 11:42:59 AM

Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A  BOLT		Purchased	No			260	Each	112.0000	2.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

111684 SP

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424 9/10/03 SP

Picklist Print

Thursday, September 03, 2009 11:42:59 AM

Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L 		Purchased	No			260 <i>230</i>	Each	350.0000	4.0000			
WASHER												

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

310

110450

2

110806

8

111819

300

D2741RevC

Manufactured

No

260

Each

40.0000

1.0000



Blade, 350 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

xy mo ea 110/21

47113 9/10/23 sf

Picklist Print

Page 17 17

Thursday, September 03, 2009 11:42:59 AM

Work Order ID: 51802



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3532-1RevA

Manufactured

No

260

Each

43.0000

2.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

44904 *scd*

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

111650 *9/10/23 SD*

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-5	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

W/O 51802

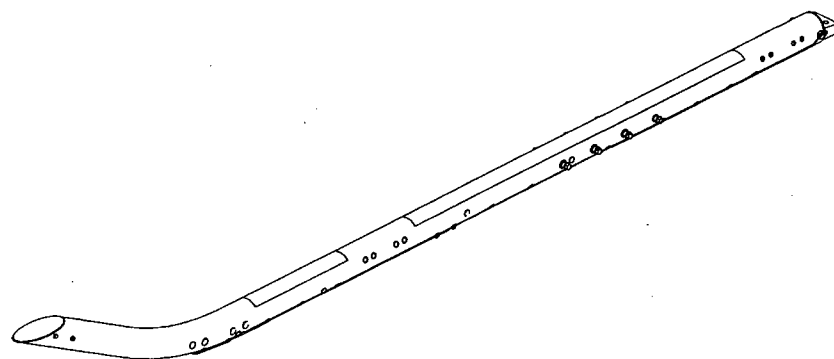
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GENERAL NOTES:

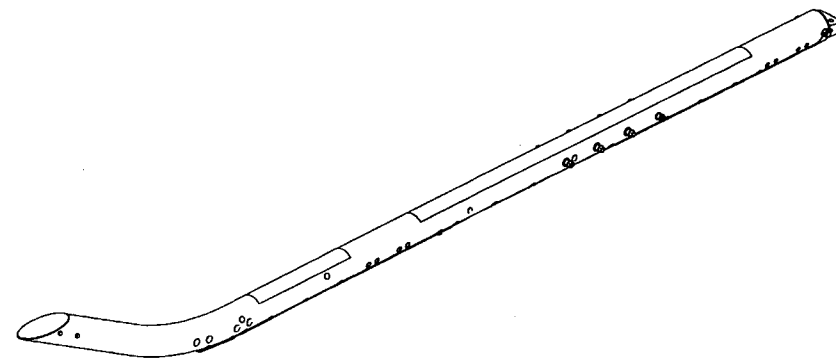
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0)
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

w/o 51802



D2750-041 350 SKIDTUBE ASSEMBLY, LH

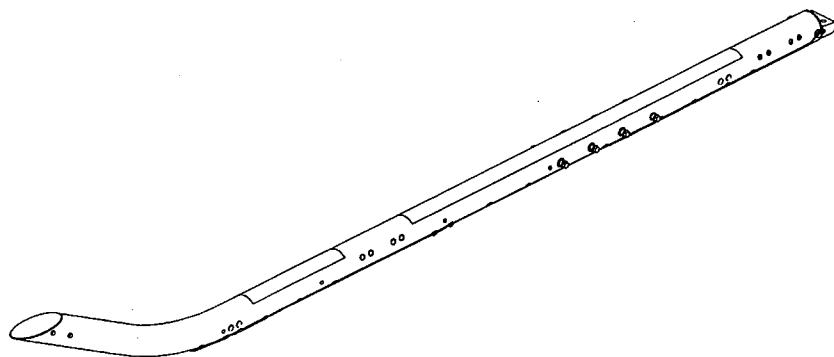


D2750-042 350 SKIDTUBE ASSEMBLY, RH

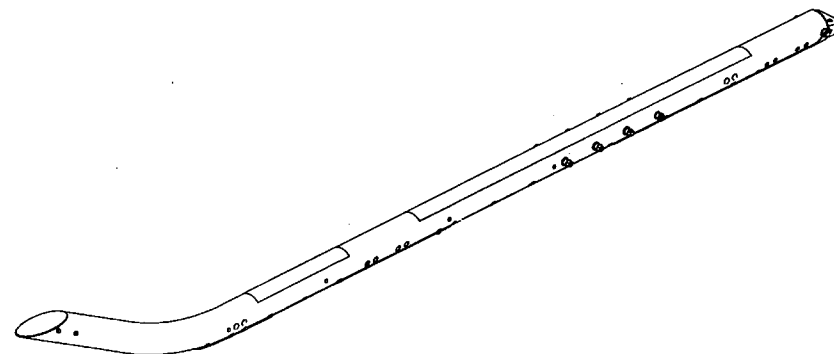
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08-22-77

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DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO.	REV. F
MFG. APPR.	AM	D2750	SHEET 2 OF 11
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
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4/0 51802



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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08-09-22/111

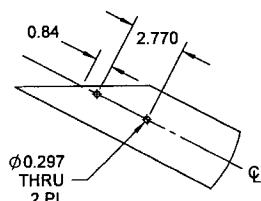
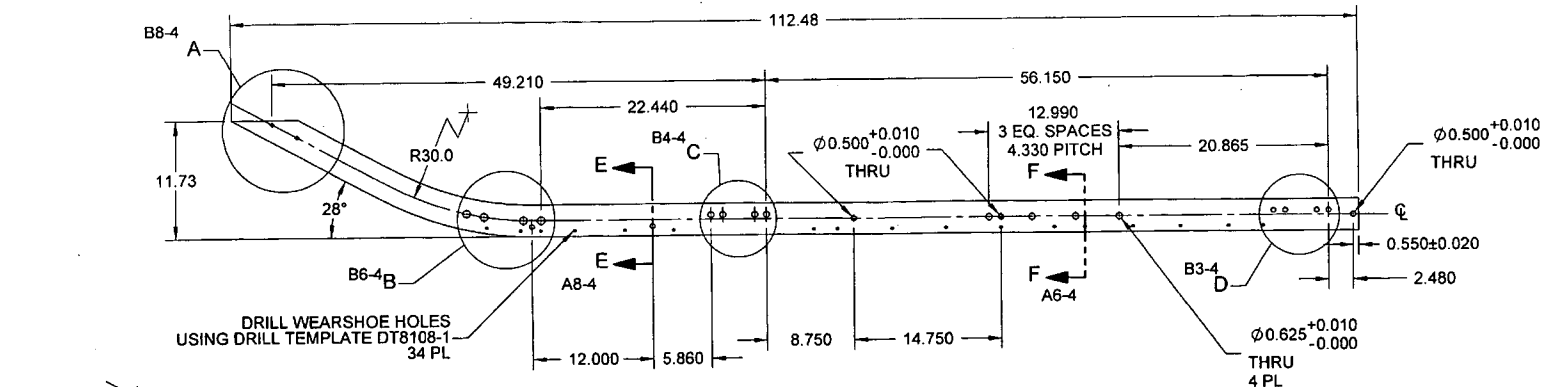
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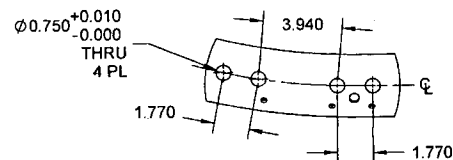
D2750-1 LH SKIDTUBE

RELEASED

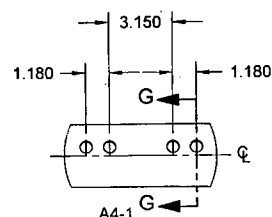
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CHECKED		DRAWING NO.	REV. F
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APPROVED		TITLE	SCALE
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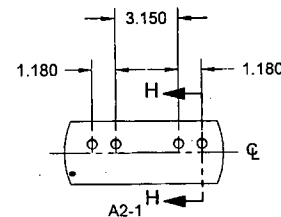
DETAIL A
SCALE 2X



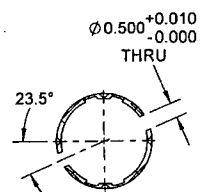
DETAIL B
SCALE 2X



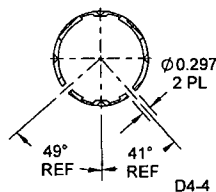
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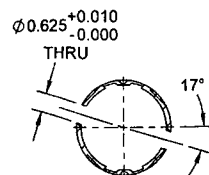
DETAIL D
SCALE 2X



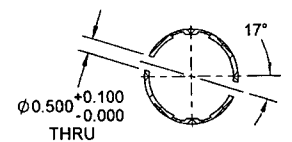
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL

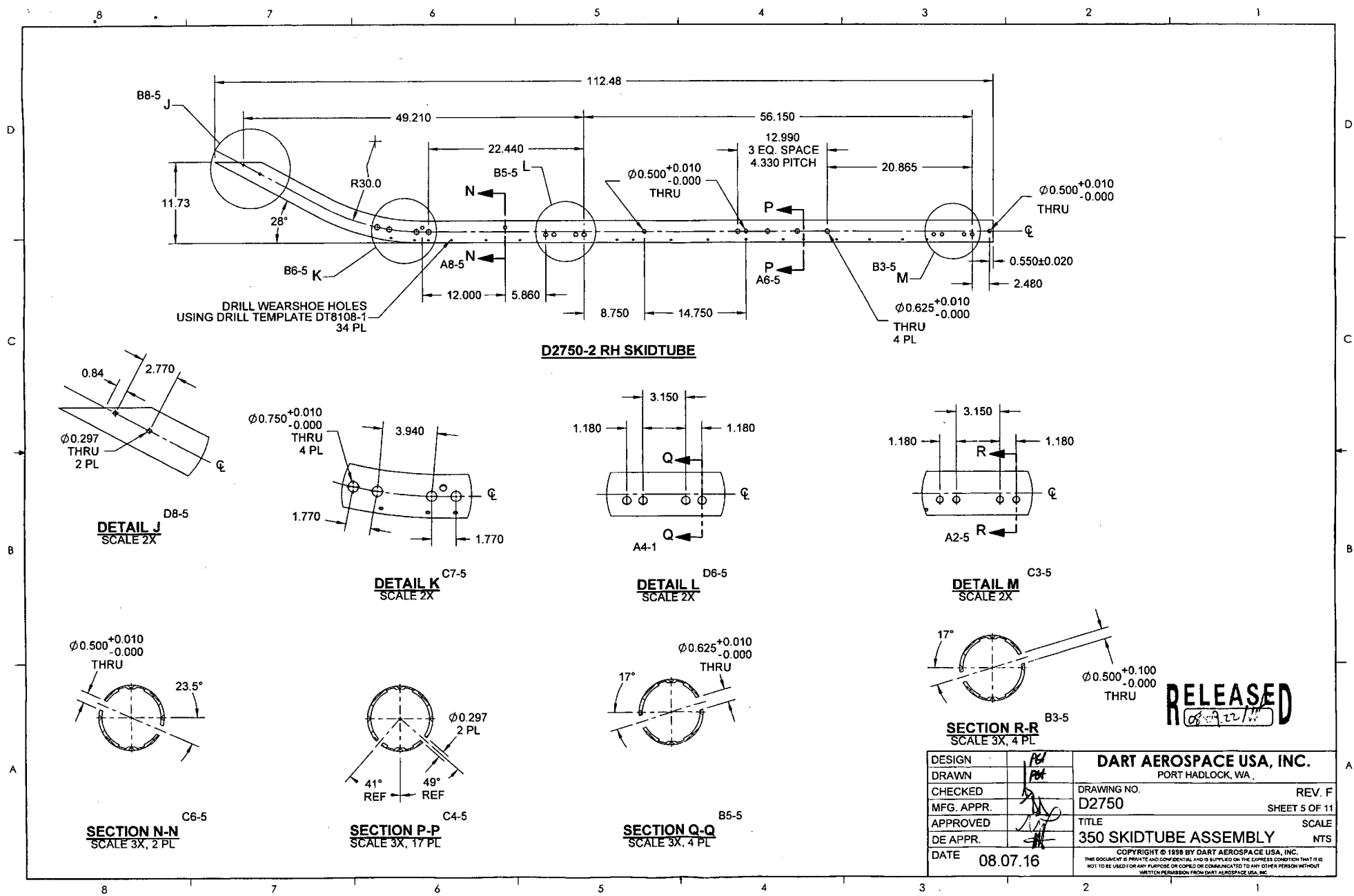


SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

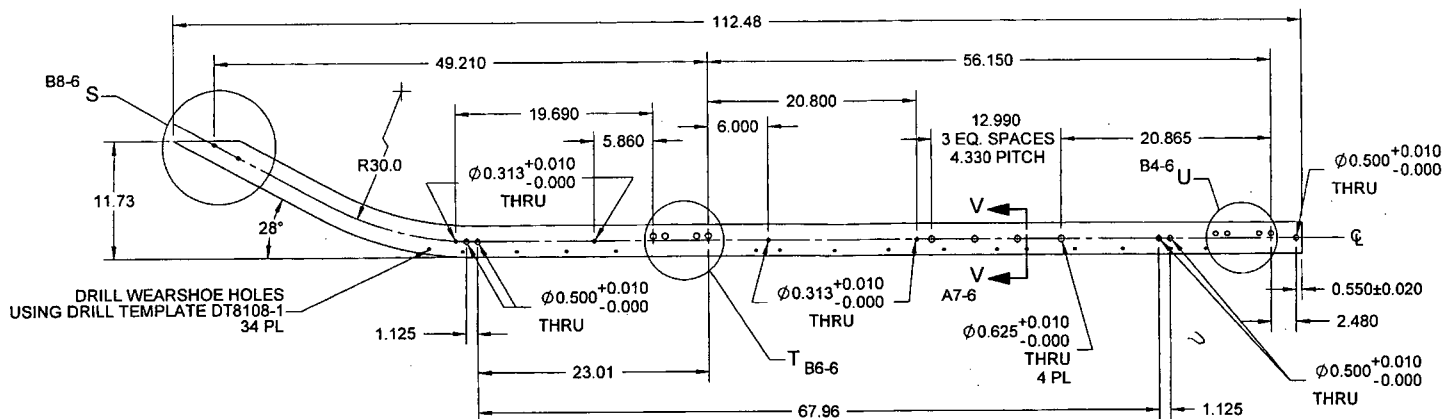
W/A 51802



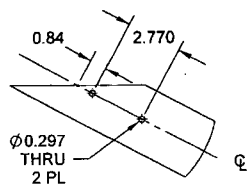
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DRAWN	REV	PORT HADLOCK, WA.	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O 51802

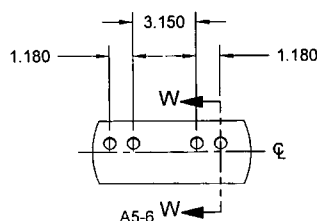
8 7 6 5 4 3 2 1



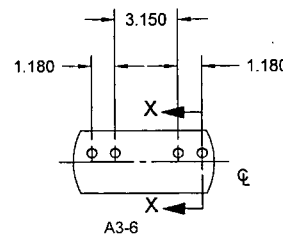
D2750-3 LH SKIDTUBE



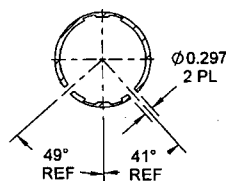
DETAIL S
D8-6
SCALE 2X



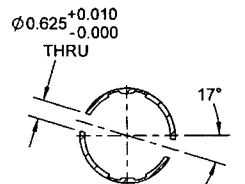
DETAIL T
C5-6
SCALE 2X



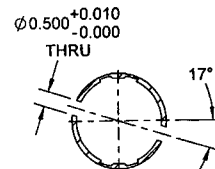
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



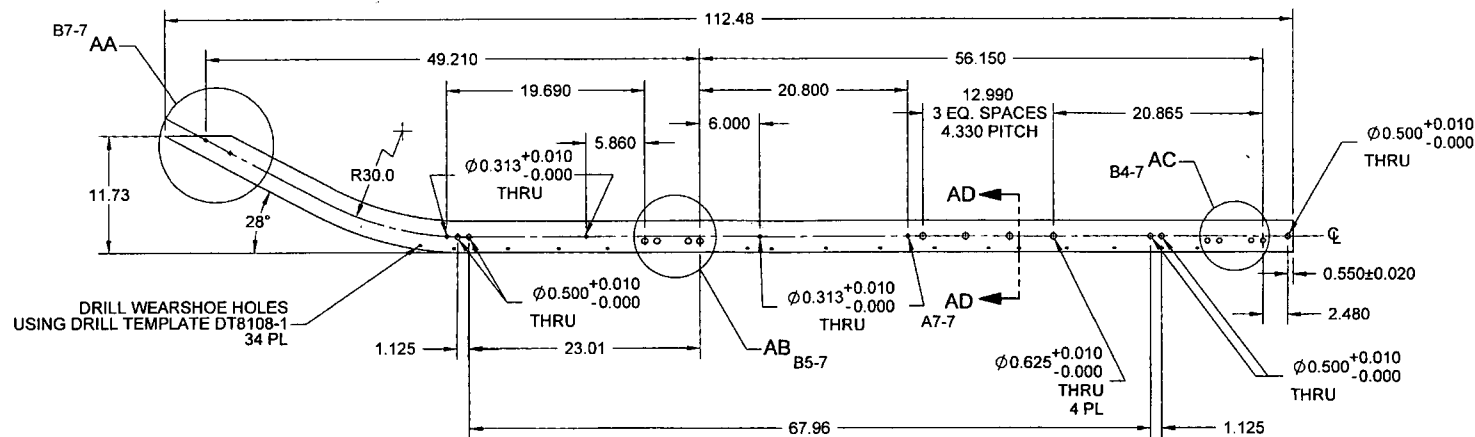
SECTION X-X
B4-6
SCALE 3X, 4 PL

RELEASED
08-07-16

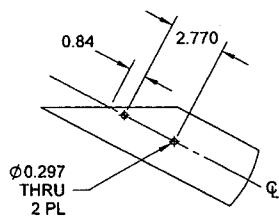
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1

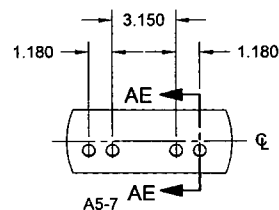
W/O 51802



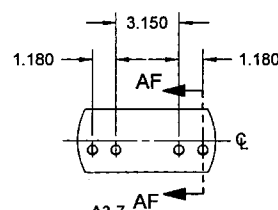
D2750-4 RH SKIDTUBE



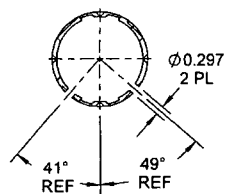
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SCALE 2X



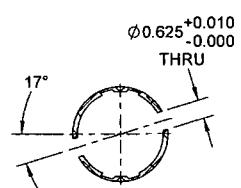
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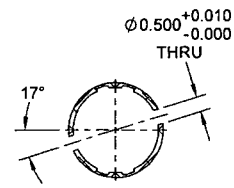
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

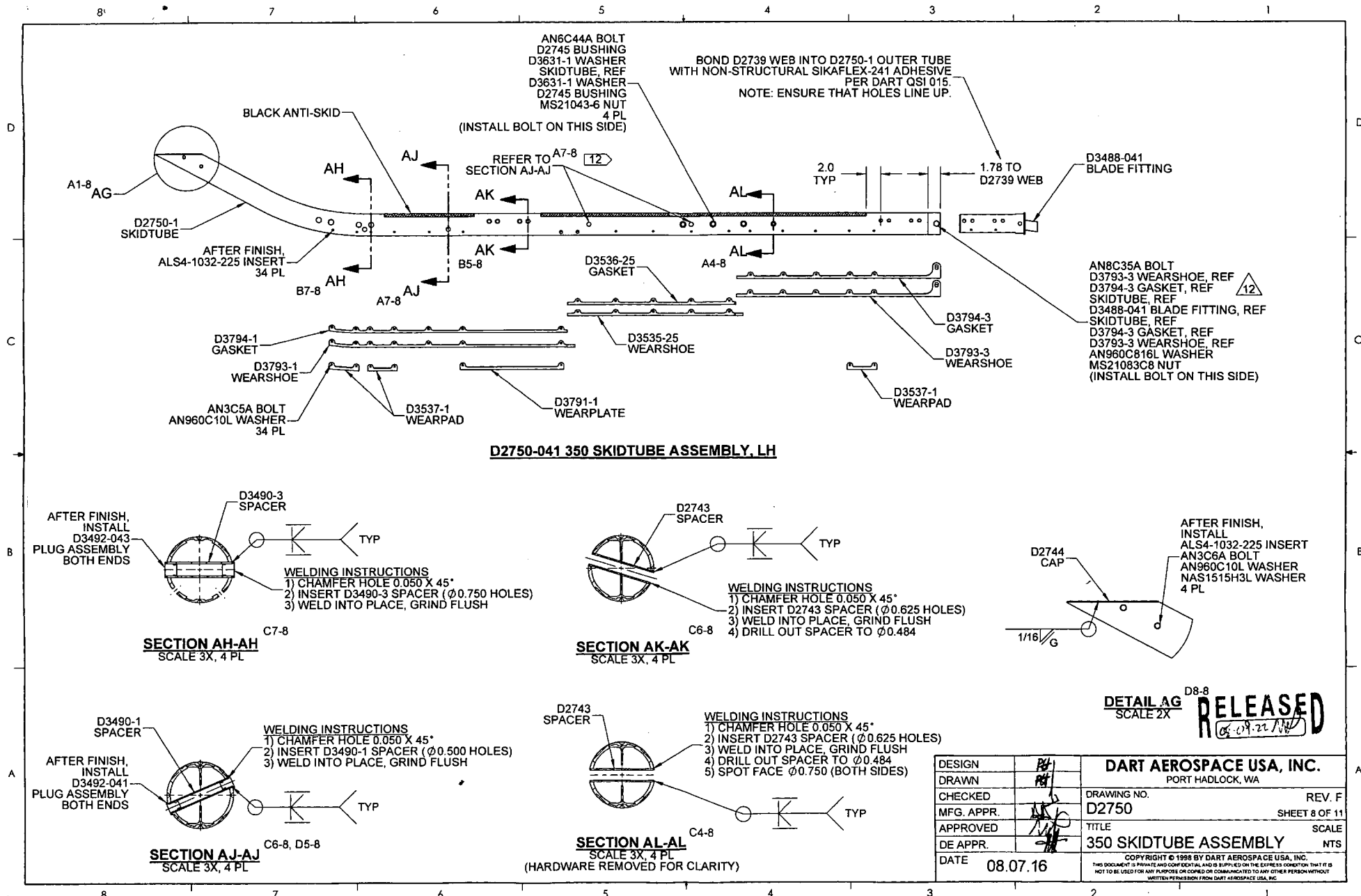


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SCALE 3X, 4 PL

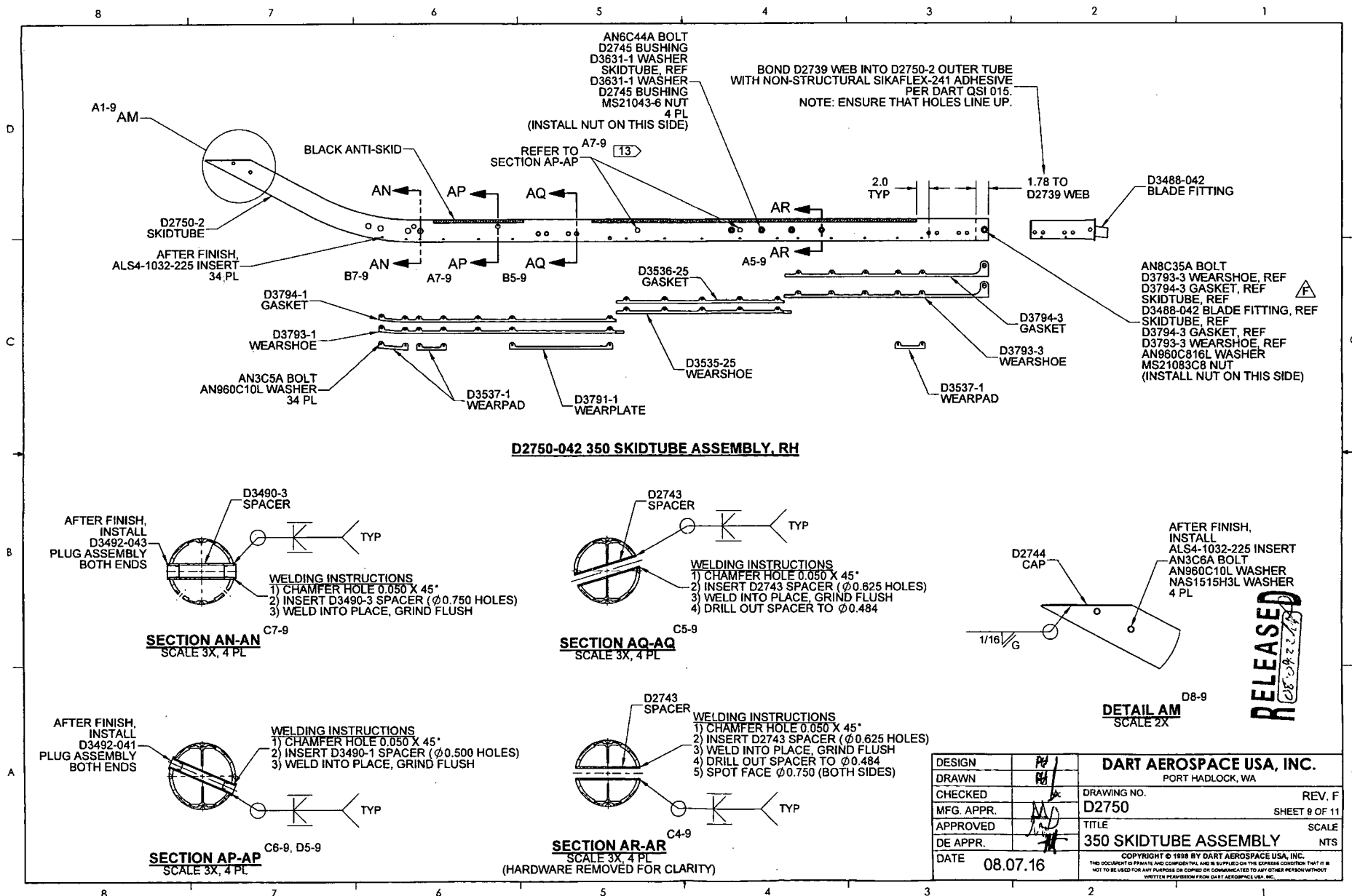
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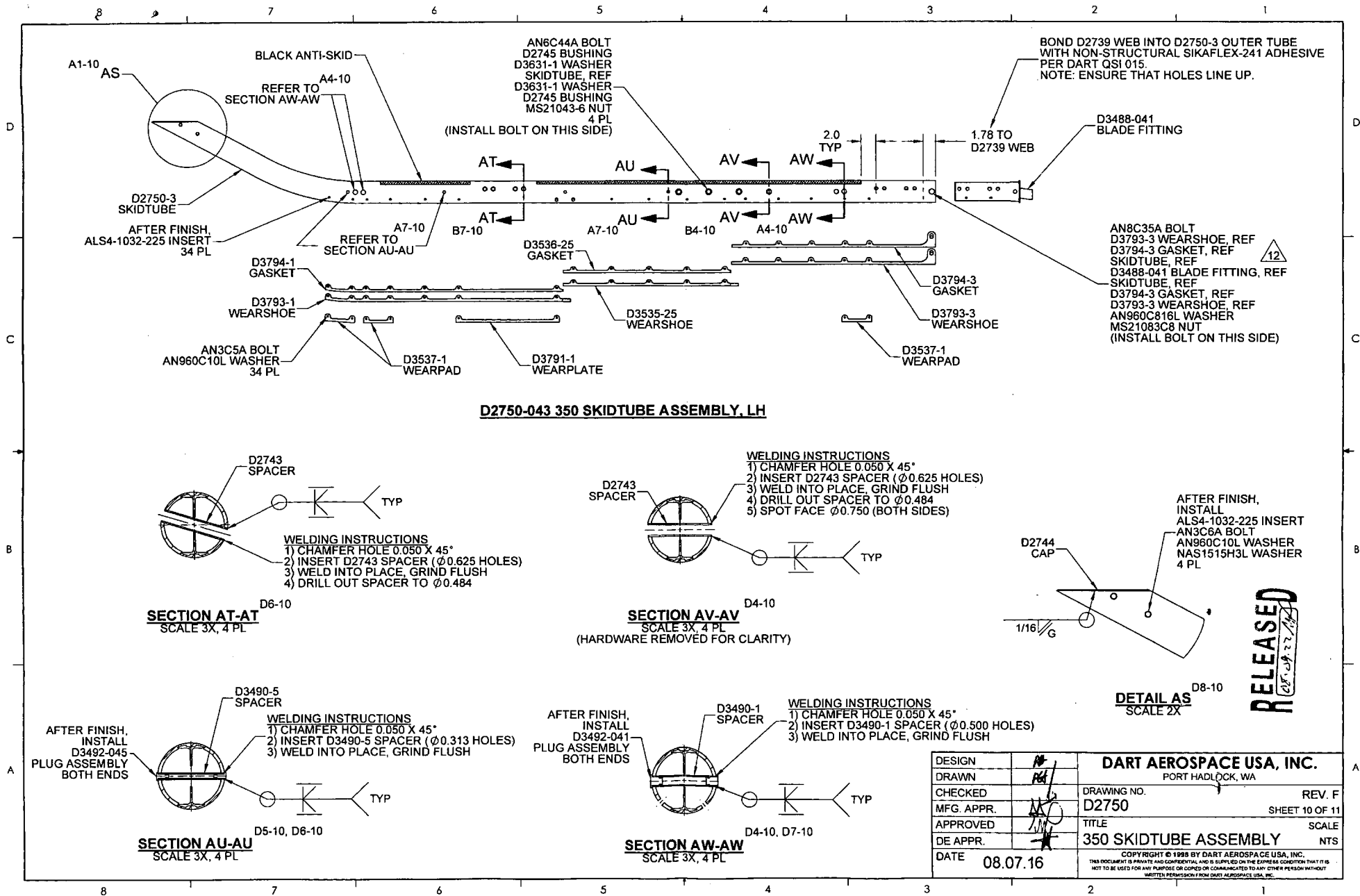








W/A 51802



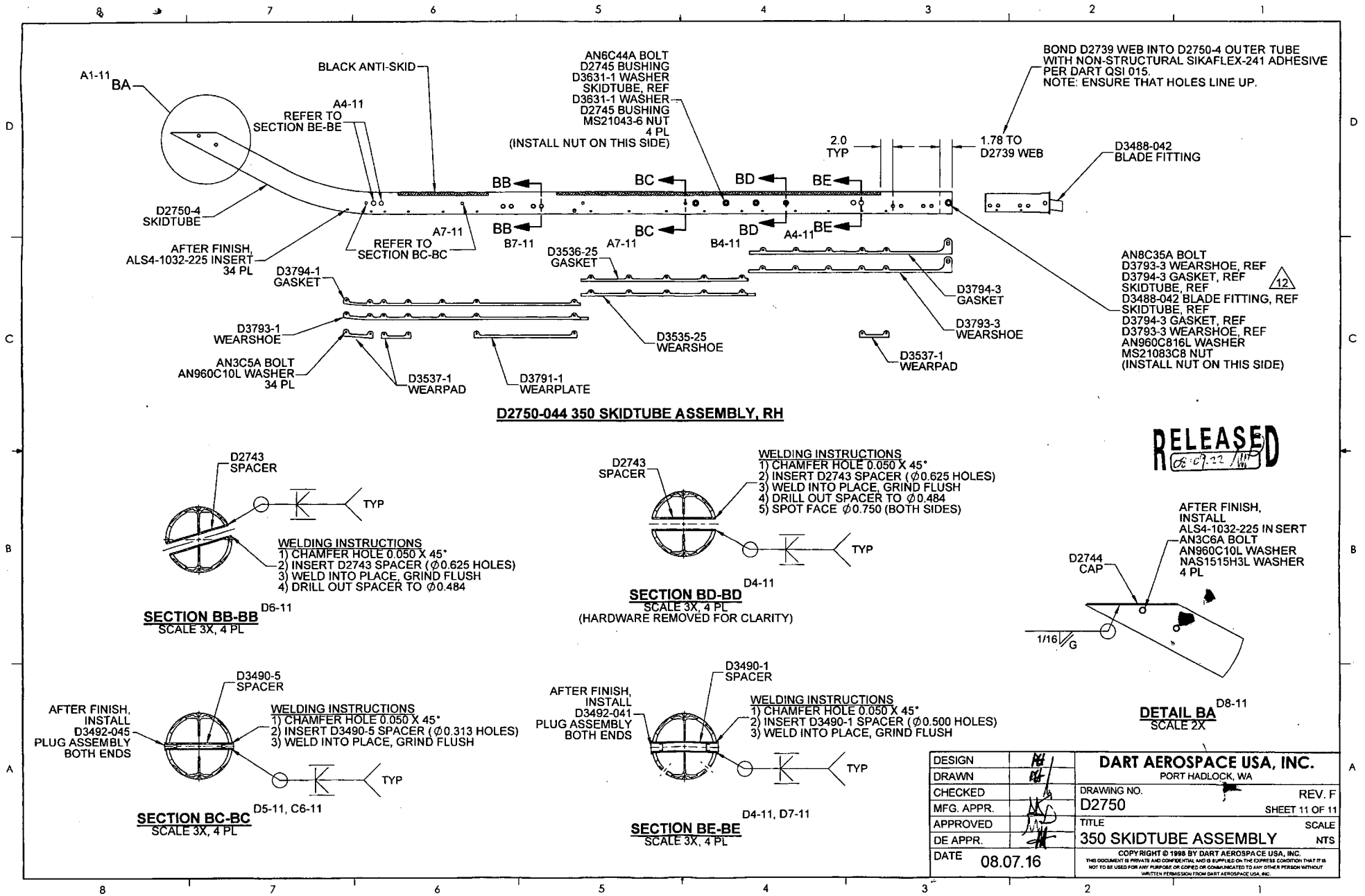
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W/O 51802

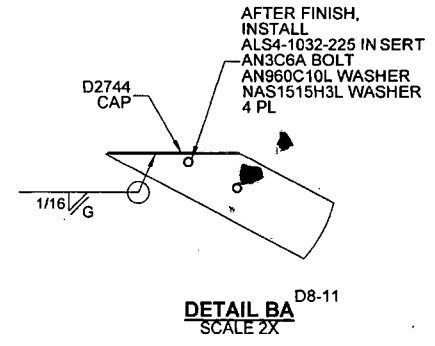
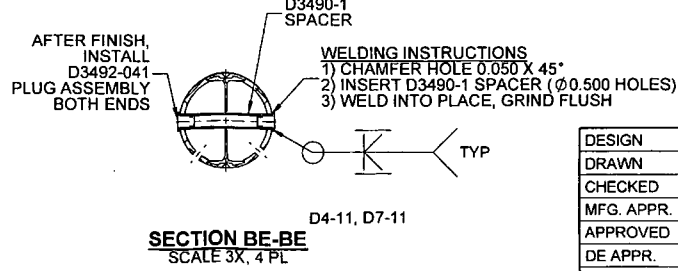
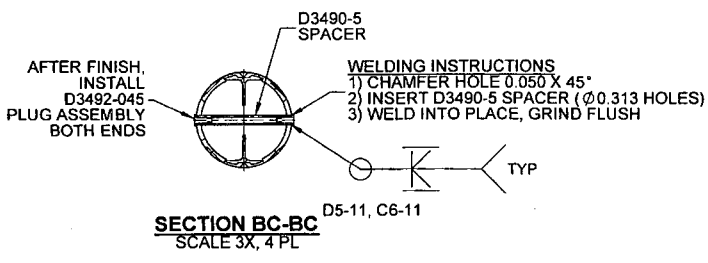
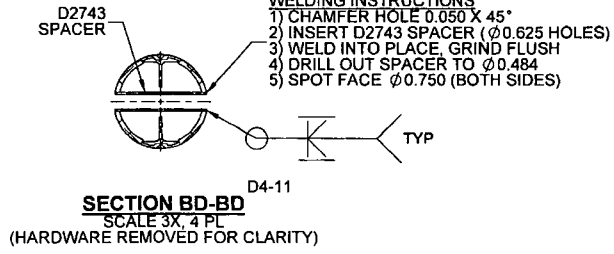
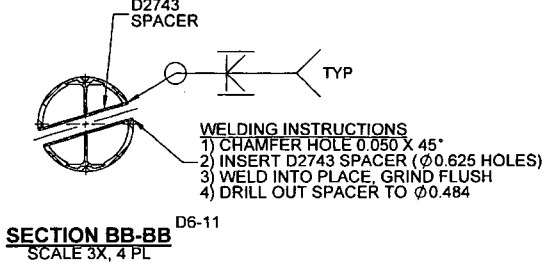


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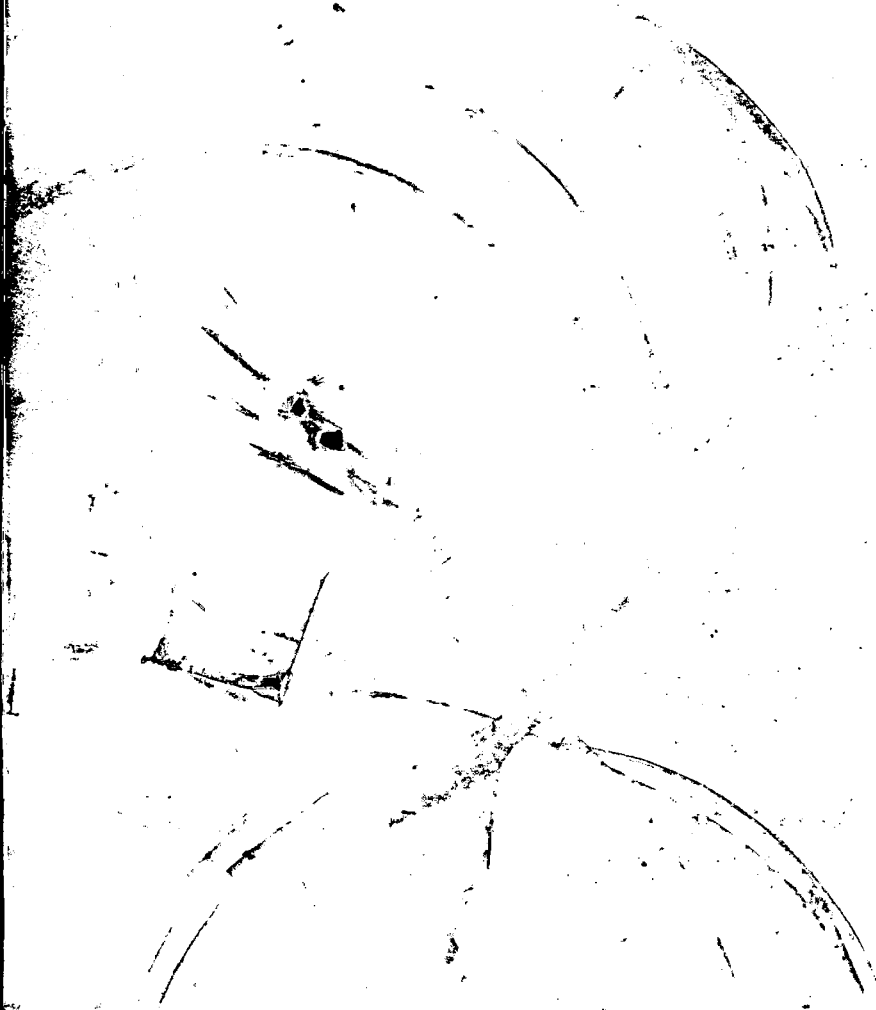
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20512 0/4



NO. 203

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 5011
Part number: D350 636 014
Description: 350 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat. Del Date of Test Coupon 09.07.14

Welder Barclay Elliott Date of Test Coupon 09.07.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 51802



Thursday, September 03, 2009 11:42:50 AM

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL MP

Date:

09-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	Rev F								

100

0.00



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PL 09-10-23

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/21	230	Replaced O-ring NAS 1611-010 for O-ring D2594-3 Batch: <u>BS1613</u>	umo	09/10/21	18	<i>[Signature]</i>	<i>S</i> 07/10/21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries